

Work Order ID 158432***158432***

Page 1

Wednesday, March 22, 2017 2:18:37 PM

Item ID: D3201-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle

Start Date: 3/27/2017 Start Qty: 3.00

3

Cust Item ID:

Required Date: 3/29/2017 Req'd Qty: 3.00

3

Customer:

Reference: SCHEDULED

Approvals: Process Plan:

DAS
21
9-89

Date: MAR 22 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3201	Rev B								
100	FLOW WATER JET	0.01							
100									
Waterjet	Memo	0.04							
FLOW CNC Waterjet	1-Cut as per Dwg D3201 (CHECK GRAIN DIRECTION BEFORE CUTTING)								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	(CHECK GRAIN DIRECTION BEFORE PASSING IN DEBBURING MACHINE)								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.03							
Quality Control									

3 PR 17/03/253 PR 17/03/25

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.06				3			DAS 38 3-89 MAR 27 2017
140 *140* Brake NC Brake NC	NC BRAKE Memo 1-Bend as per Dwg D3201	0.14 0.10			DAS 30 9-89	3			MAR 28 2017
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.06				3			DAS 38 3-89 MAR 29 2017

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

3

3

Customer:

Run Start *NR1*

Stop *NP2*

Date:

Insp. Stamp

0.00

160

HandFinish

Memo

0.09

Hand Finishing

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.03

Quality Control

180

Identify as per dwg & Stock Location: 5023

0.00

180

Packaging

Memo

0.03

Packaging

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Cust Item ID:

Required Date: 3/29/2017 Req'd Qty: 3.00

3

Customer:

Reference: SCHEDULED

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.30

Quality Control

17/3/30 JF
ME
17-3-24

Picklist Print

Wednesday, March 22, 2017 2:18:42 PM

Work Order ID: 158432

158432

Parent Item: D3201-3

D3201-3

Parent Item Name: Angle

Start Date: 3/27/2017

Required Date: 3/29/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev: A Removed from 9 Digit 06-01-25 JLM
 IPP Rev:B Now on Waterjet 06-08-14 JLM
 IPP Rev C added scribing NCR262 07.11.29 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	57.4100	0.045	0.142105			
M2024T3S 050									**	PR 17/03/25			
2024-T3 .050 sheet													

Location

Loc Qty

Loc Code

MAT022

57.410026

m131564

0.55

m134581

32.1

m135610

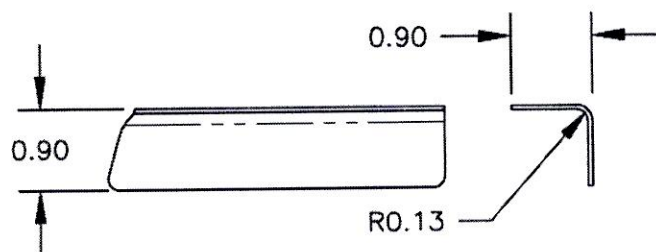
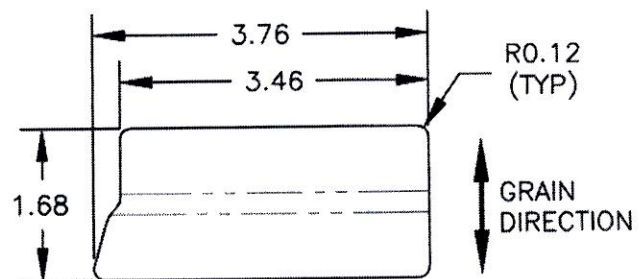
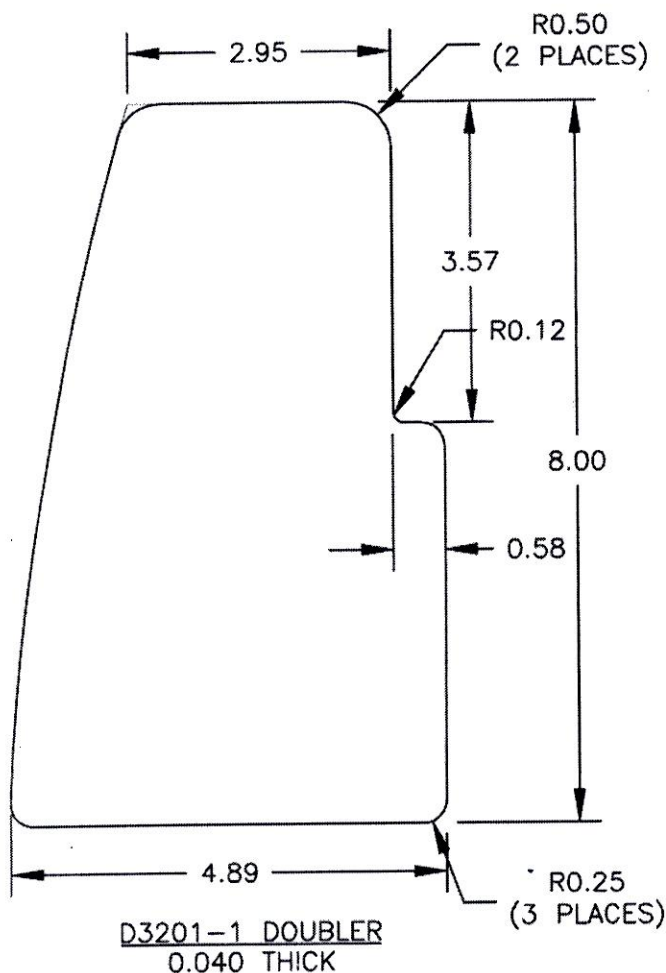
24.760026

0.12



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE 03.11.03	TITLE DOUBLER		SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

RELEASED
03.11.04



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 158432mcs
170322

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